

Work Order ID 165113

Tuesday, August 15, 2017 3:20:21 PM

165113

Page 1

Item ID: D4634-143 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Middle, Center Ceiling Replacement Panel Assembly
Start Date: 8/21/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/25/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: AUG 16 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4634	G

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Pick Kit

SEP 08 2017

DAS
6
9-89

110

0.00

110

Small Fab

Memo

1.30

Small Fab

Assemble as per Dwg D4634-143

1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe

2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.

Batch # M 137679Expiry Date Sept 27/17

3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer

(i)DAS
07
9-8917/09/12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.02							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.01							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
27
9-89
17/9/18

DAS
07
9-89

17/09/18

17/9/2017

(N)

SEP 18 2017

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WORK ORDER NON-CONFORMANCE / UPDATE



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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 165113

165113

Parent Item: D4634-143

D4634-143

Parent Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Document release DL VERIFIED BY:JLM
Dwg Update DL verf: DD
DL
DL
DL
IPP Rev B
IPP Rev C 13/07/09
IPP Rev D Dwg Update 13/12/23
IPP REV E Dwg update 14/01/09
IPP Rev F Dwg. update 14/02/03
IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4647-1 *D4647-1* Doubler		Manufactured	No			100	Each	4.0000	1	1		DAS 6 9-89	SEP 09 2017
				<u>Location</u>				<u>Loc Qty</u>					
				MF004				4					
				155284				4					
D5021-3 *D5021-3* Foam, Center Panel, Middle		Manufactured	No			100	Each	3.0000	1	1		DAS 6 9-89	SEP 09 2017
				<u>Location</u>				<u>Loc Qty</u>					
				ST479a				3					
				154854				3					
MS21059L08 *MS21059L08* Nut		Purchased	No			100	Each	99.0000	2	2		DAS 6 9-89	SEP 09 2017
				<u>Location</u>				<u>Loc Qty</u>					
				ST300				99					
				m134943				1					
				m136554				98					

DQA: _____ Date: _____



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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
								OTHER :	

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165113

Parent Item: D4634-143

D4634-143

Parent Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-4

Purchased

No

100

Each

7,218.000

4

4

MS20426AD3-4

RIVET

**

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

5644

m134294

1921

m136444

3723

ST312

1574

m131697

48

m134294

1526

MS20426AD4-6

Purchased

No

100

Each

984.0000

4

4

MS20426AD4-6

Rivet

**

DAS
6
9-89

SEP 09 2017

Location

Loc Qty

Loc Code

CCK004

861

M137851

861

GA

37

M134502

25

M137851

12

ST311

86

M136537

86

D4634-3

Manufactured

No

100

Each

0.0000

1

1

D4634-3

Middle, Center Ceiling Panel

D4636-5

Manufactured

No

100

Each

37.0000

2

2

D4636-5

Bracket

**

①

Dh
11/09/17

wo* 164289

**

DAS
6
9-89
SEP 09 2017

Location

Loc Qty

Loc Code

ST115

37

154916

17

164519

20

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WORK ORDER NON-CONFORMANCE / UPDATE

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Parent Item: D4634-143

D4634-143

Parent Item Name: Middle, Center Ceiling Replacement Panel Assembly

Start Date: 8/21/2017

Required Date: 8/25/2017

Start Qty: 1.00

Required Qty: 1.00

D4664-5

Manufactured No

100 Each

9.0000

6 6

D4664-5

Spacer

**

16106623 **DAS 6 9-89** **SEP 11 2017**

Location

Loc Qty

Loc Code

MF004

9

155824

9

3

D4712-1

Manufactured No

100 Each

2.0000

2 2

D4712-1

Bracket

**

161607X1 **DAS 6 9-89** **SEP 11 2017**

Location

Loc Qty

Loc Code

MF004

2

163711

2

1

D4732-21

Manufactured No

100 Each

7.0000

1 1

D4732-21

Label

**

DAS 6 9-89 **SEP 11 2017**

Location

Loc Qty

Loc Code

MF005

7

123210

7

1

D4732-25

Manufactured No

100 Each

8.0000

1 1

D4732-25

Label

**

DAS 6 9-89 **SEP 11 2017**

Location

Loc Qty

Loc Code

MF005

8

120073

1

123212

7

1

MPNY-750S-9-C

Purchased No

100 Each

603.0000

3 3

MPNY-750S-9-C

Mounting Pad

**

DAS 6 9-89 **SEP 09 2017**

Location

Loc Qty

Loc Code

ST569

603

M130423

603

3

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Shop Packet Print

Page 3

DQA: _____ Date: _____

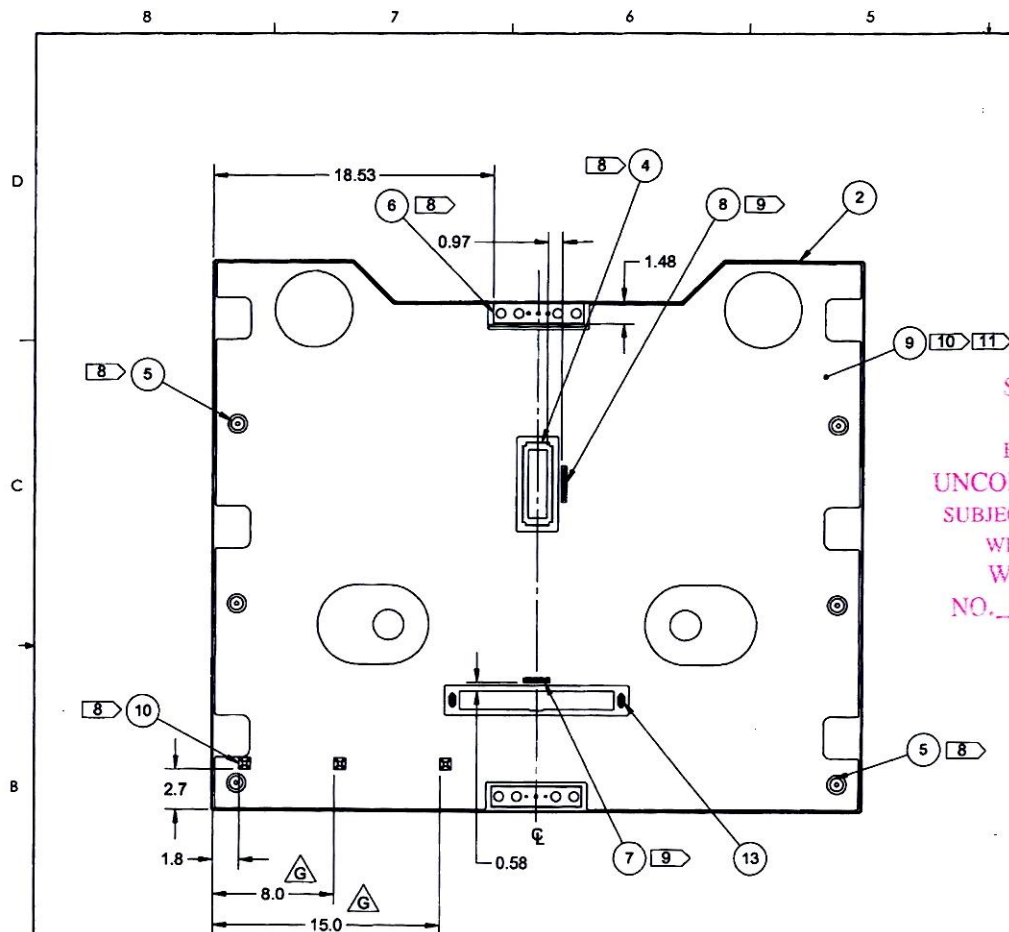
WORK ORDER NON-CONFORMANCE / UPDATE



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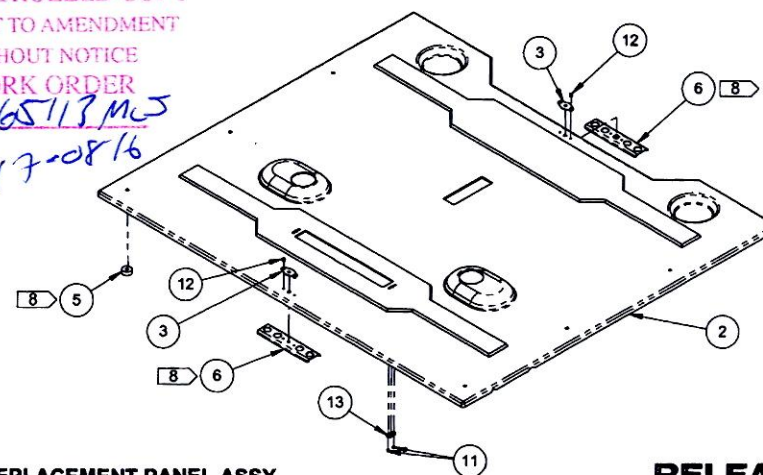
D4634-143 MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1, D4664-5 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN. SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-3 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-3 FOAM ON D4634-3

ITEM	QTY -143	P/N	DESCRIPTION
1	X	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-3	MIDDLE, CENTER CEILING PANEL
3	2	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4664-5	SPACER
6	2	D4712-1	BRACKET
7	1	D4732-21	LABEL
8	1	D4732-25	LABEL
9	1	D5021-3	FOAM, CENTER PANEL, MIDDLE
10	3	MPNY-750S-9-C	MOUNTING PAD
11	4	MS20426AD3-(4)	RIVET, SOLID, CSK
12	4	MS20426AD4-(6)	RIVET, SOLID, CSK
13	2	MS21059L08	NUT PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165113 MJS
17-0816



RELEASED

2015 JAN 26

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	AK	DRAWING NO.	REV. G
	MFG. APPR.	DL	D4634	SHEET 8 OF 17
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CENTER CEILING PANELS	NTS
	DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	